

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2015-80 Date Opened: 08-Jul-15 Title: AssemblyAircraft OEM: Eurocopter Aircraft Model: AS350/355 Product Type: Cargo Basket Product Model: Medium Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
76410	3	Basket Assembly	JC
70405	4	Lid Walkway	JC
84261	2	Handle Assembly	JC

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
0
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Install walkway on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

JC
JC
JC
JC
JC
JC
JC

Work performed by:

Print: Jeff Clarke

Sign: 

SCA: AD02

Date: 08-Jul-15

ICC / Dual Inspection performed by:

Print: Jason Rekve

Sign: 

SCA: AD01

Date: 08-Jul-15

Work Order closed by:

Print: Jeff Clarke

Sign: 

SCA: AD02

Date: 08-Jul-15

Approved Manufacturing Facility 73-04

Form 20.D:08

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

69812-01

Aircraft:

Bell

Model: 407

Description:

Standard Lid

Supplier:

N/A

Color:

White

WO#:

2015-36

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:	50		
PN:	AN3-12A		
Aircraft:		All	Alt:
Description:	Bolt		Model: All
Supplier:	Aviall		
Color:	N/A		
WO#:	N/A		
		PO# Several	

CARGO BASKET HANDLE FABRICATION

General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2015-80

Complete
(initial or SCA #)

Date Open: 08 JULY 2015

WO 2015-42

1. Weld Lever Assembly – handle lever jig required
 - a. Set MS20615-4M3 monel rivet into socket in jig
 - b. Set 36274-01 bushing into socket in jig
 - c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
 - d. TIG weld around bushing using ER308L rod.
 - e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
 - f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
 - g. Record material POs on attached material list.
2. Clean up
 - a. Clean lever assembly by media blasting with glass bead.
 - b. Drill out lever bushing to O (0.316) on lathe:
 - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
 - ii. Run at 300 RPM.
 - iii. Apply a drop of Rapid-Tap to drill.
 - c. De-burr.
3. Fabricate Handle Assembly
 - a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
 - b. Measure across TOP side of levers.
 - c. Cut handle tubing to length measured.
 - i. Handles under 40" long: 1.0" x 0.035 round tube
 - ii. Handles over 40" long: 1.0" x 0.065 round tube
 - d. De-burr tube.
 - e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
 - f. Record material PO on attached material list.
4. Weld Handle Assembly
 - a. Fuse tube to lever on both ends. Ensure levers are parallel.
5. Clean up
 - a. Clean welded area with scotch-brite.
6. Final Inspection –

To be completed by a different person than the previous steps.

 - a. Welds for complete and handle for fit.
 - b. Tag complete and inspected parts in preparation for installation.

jc.

AD-05

jc.

AK

Work Order: 2015-80Material Tracking Sheet
AS350 / AS355 Medium Basket Handle Assembly

1 of 1

Date Opened: 08 July 2015

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>	84261	84261-01	Handle Assembly		
Step 1				<i>Weld Lever Assembly</i>		<i>WO 2015-42</i>
	. 2		84265-01	Lever	304 Stainless, 0.105 Sheet	
	. 2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	
	. 2		MS20615-4M3	Rivet		
	. A/R		--	Welding Rod	ER308L TIG Rod	
Step 2				<i>Clean Up</i>	<i>None</i>	
Step 3				<i>Fabricate Handle Bar</i>		
	. 1		36277-01	Handle Bar	304 Stainless, 1.0 x 0.035 Rnd. Tube	<i>14060</i>
Step 4				<i>Weld Handle Assembly</i>	<i>None - Fuse weld, no rod req.</i>	
Step 5				<i>Clean Up</i>	<i>None</i>	
Step 6				<i>Inspection - Final Assembly</i>	<i>None</i>	



Description: _____

WO# _____

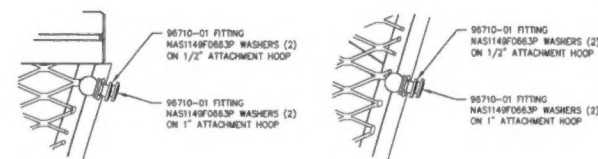
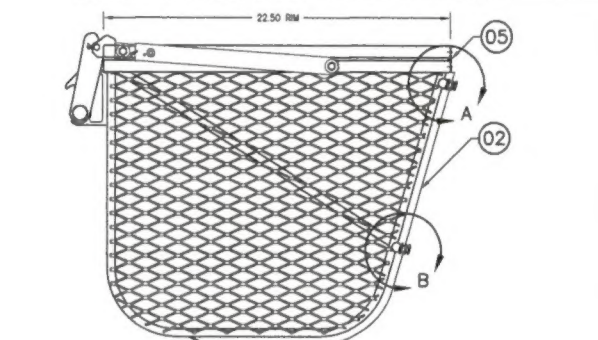
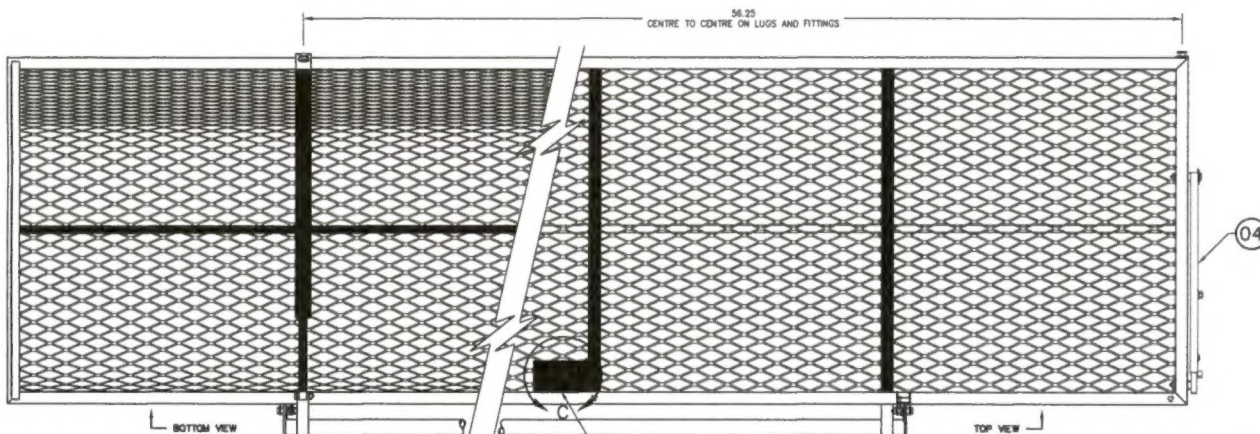
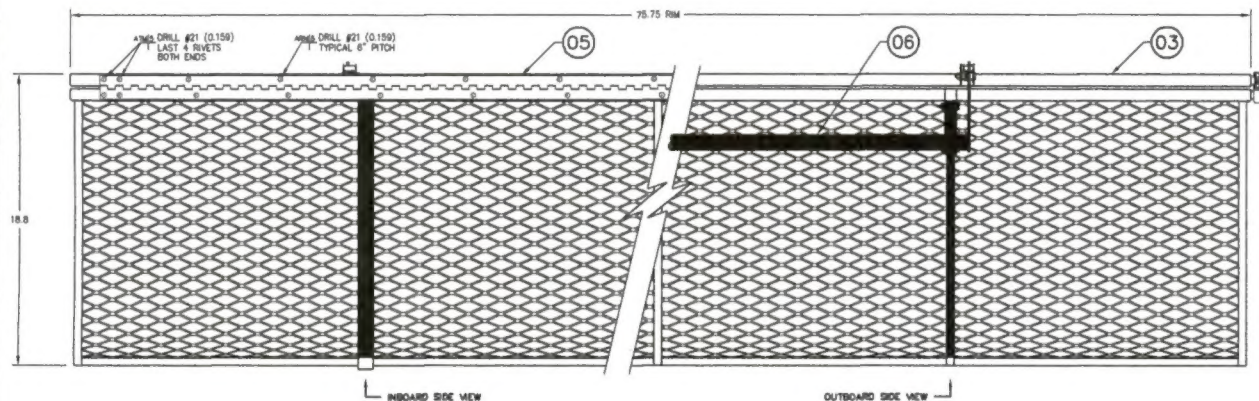
SEE MATERIAL TRACKING
SHEETS



2015-80 JK.
WO# 2015-77

Approved Manufacturing Facility 73-04 Form 20.F.06 Rev. Original 27 May 2013

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	14 JAN 08
1	ADDED LH ASSEMBLY	RR	05 MAR 09
2	CHANGED HANDLE CONFIGURATION	BJC	27 JAN 10
3	UPDATE TITLE BLOCK; ADD ALTERNATE RIVETS; HARDWARE P/N'S UPDATED; CHANGE BRACE ASSEMBLY TO INSTALLATION	BJC	10/07/2014



DETAIL A
SCALE 1 : 2
TYPICAL FRONT AND REAR

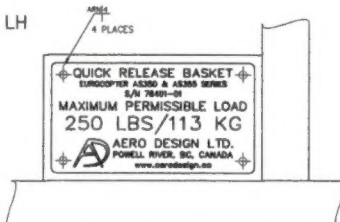
DETAIL B
SCALE 1 : 2
TYPICAL FRONT AND REAR

NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

A/R/L/R	QTY	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
4	4	06710-01	FITTING			
8	8	CR3523-5-02	CHERRY RIVET			
4	4	CR3213-5-02	CHERRY RIVET			
4	4	CR3213-4-02	CHERRY RIVET			
3	3	49205-14	08 BUMPER			
1	1	76427-01	07 PLACARD			
1	1	84255-01	28 HANDLE BAR INSTALLATION			
1	1	MS20001P4	05 PIANO HINGE			72.0 LONG
1	1	84240-01	04 LID BRACE INSTALLATION			
1	1	69812-01	03 BASKET LID ASSEMBLY			
1	1	76411-01-02	02 BASKET BODY ASSEMBLY (LH)			
1	1	76411-01-01	02 BASKET BODY ASSEMBLY (RH)			
1	1	76410-01-02	01-02 CARGO BASKET ASSEMBLY - LH			
1	1	76410-01-01	01-01 CARGO BASKET ASSEMBLY - RH			
01	01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC
QTY	QTY					

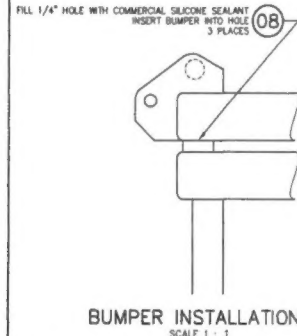
LIST OF MATERIALS

BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF: NAS 523	N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE	GRAPH: R. RATHWELL	14 JAN 08
C=COUNTERSUNK	D=DIMPLE	CHECKED:	
DIGIT=# OF SHEETS TO BE DIMPLED	DASH NO. FOR LENGTH	E. BURCON	
BASIC CODES: BU=MS20470AD BB=MS20426AD ARH=CR3213 ATM=CR3523	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS X.XXX ±0.010 X.XX ±0.03 X.X ±0.1	ANGLES ±1/2°	
	INSTALL NEW RIVET REMOVE/REPLACE RIVET EXISTING RIVET		



DETAIL C
SCALE 1 : 1
LOOKING AT PLACARD BRACKET

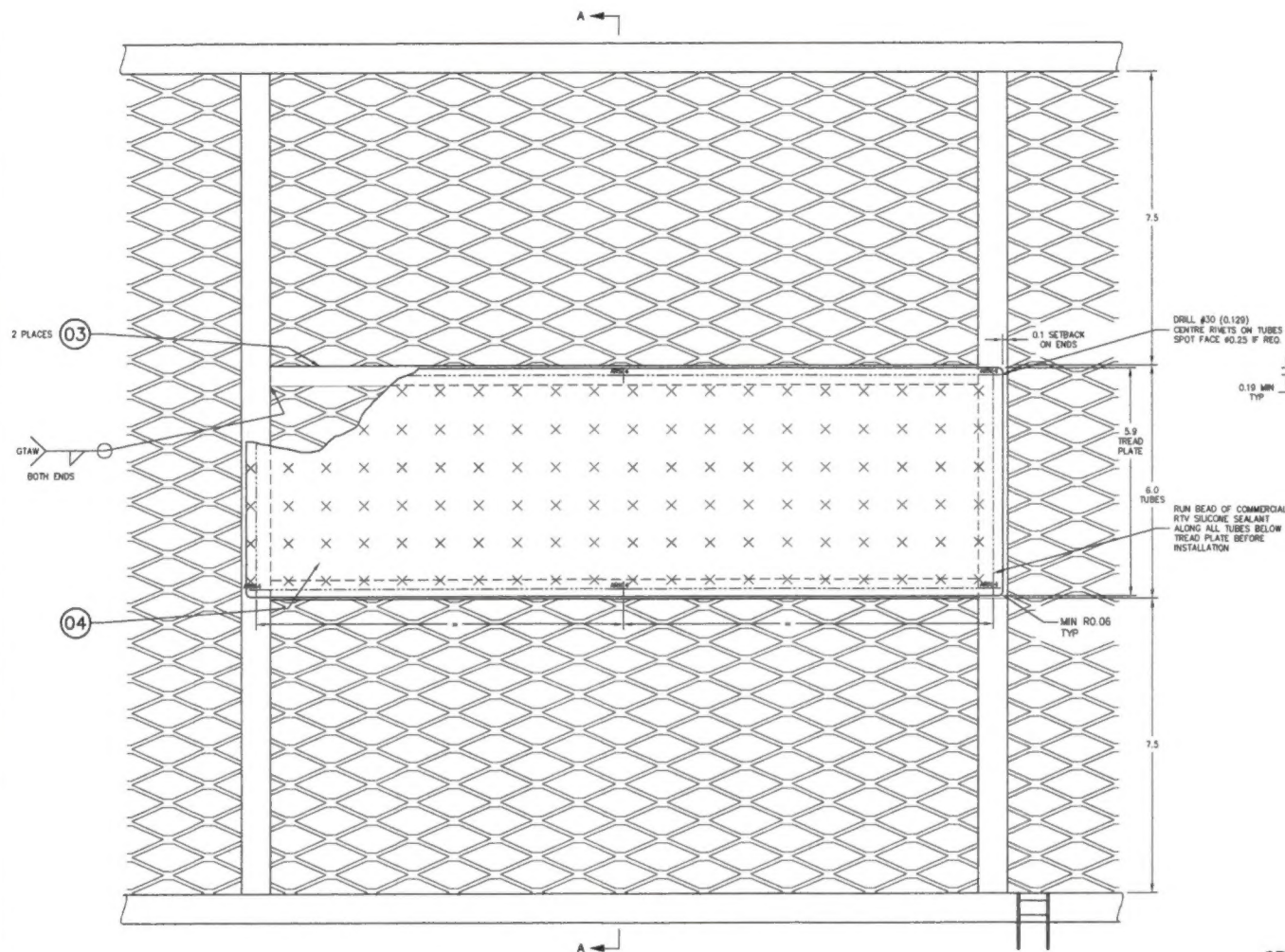
764 10 -01-01 CARGO BASKET ASSEMBLY - RH
SHOWN
764 10 -01-02 CARGO BASKET ASSEMBLY - LH
OPPOSITE



BUMPER INSTALLATION
SCALE 1 : 1

AERO DESIGN LTD.			
8888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.480.5075 www.aerodesign.ca			
EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY (MEDIUM)			
SCALE 1 : 4	DWG SIZE	DWG NO.	REV.
SHEET 1 OF 1	A1	76410	3

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD600N, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	29/05/2014



NOTES:

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

SECTION A-A

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02
1	70405-04 04	TREAD PLATE	ALUMINUM
2	70405-03 03	TUBE	4130 STEEL COND. M
1	SEE NOTE 1 02	BASKET LID ASSEMBLY	COMMERCIAL
1	70405-01 01	BASKET LID ASSEMBLY - MODIFIED WITH STEP	MIL.-T-6736
01	PART NO.	ITEM	DESCRIPTION
QTY			MATERIAL MATERIAL SPEC STOCK SIZE

LIST OF MATERIALS

BASIC CODE		DASH NO. FOR DIAMETER		DASH NO. FOR LENGTH		APPROVALS		DATE	
REF. NAS 523		N=MFD. HEAD NEAR SIDE		F=MFD. HEAD FAR SIDE		DRAWN: JEFF CLARKE		21 SEPT 2008	
C=COUNTERSUNK		D=DIMPLE		DIGIT=# OF SHEETS TO BE DIMPLED		CHECKED: E. BURGOIN			
BASIC CODES:		+ INSTALL NEW RIVET		+ REMOVE/REPLACE RIVET		UNLESS OTHERWISE SPECIFIED		DIMENSIONS ARE IN INCHES.	
BJ = MS20470AD		+ EXISTING RIVET				TOLERANCES ON:		DECIMALS	
BB = MS20426AD						X.XX ±0.010		ANGLES	
ARM = CR3213						X.XX ±0.03		±1/2"	
ARM = CR3212						X.X ±0.1			



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TEL: 604.683.2376 www.aerodesign.ca

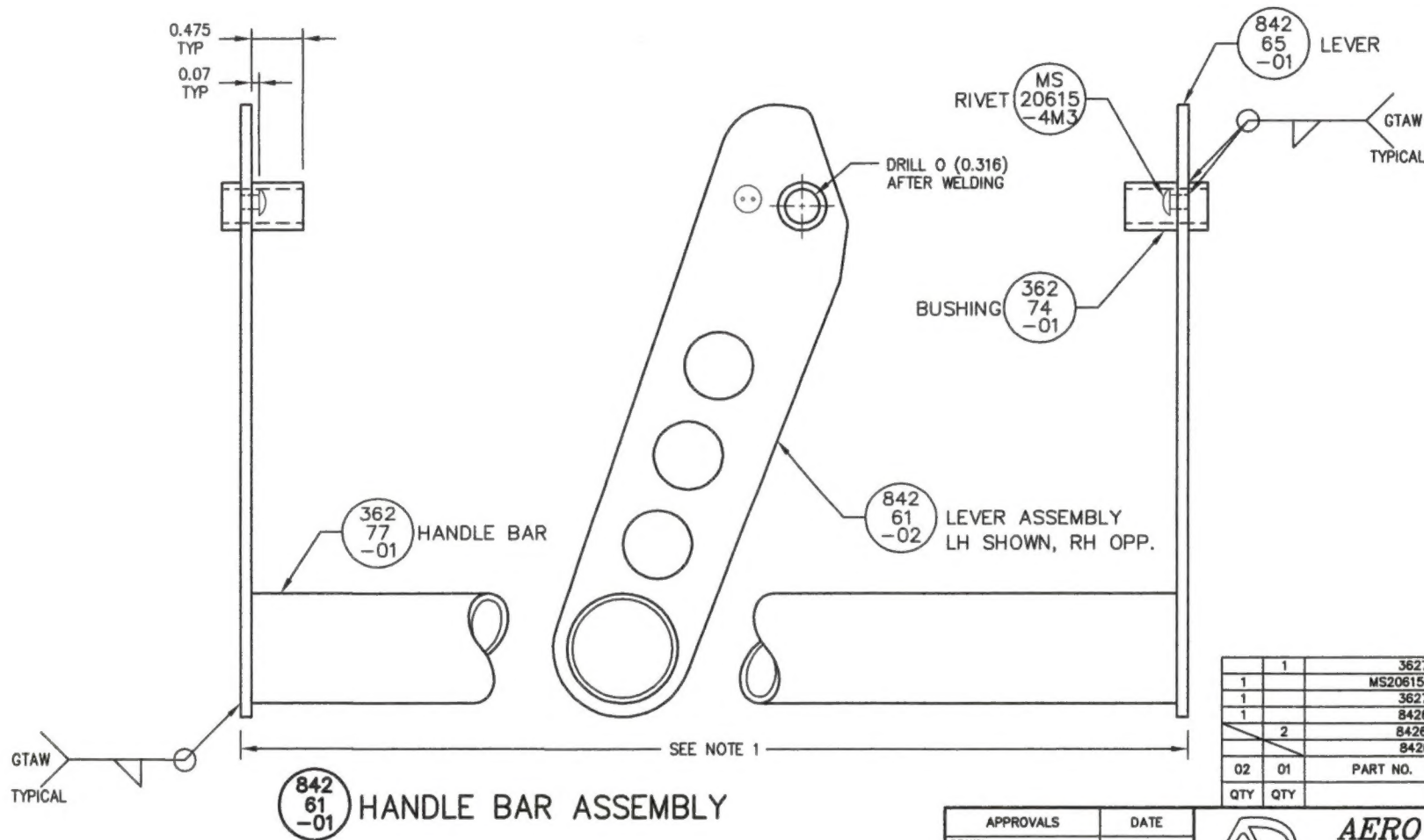
CARGO BASKET LID STEP MODIFICATION

SCALE	DWG SIZE	DWG NO.	REV.
SCALE 1 : 1.5	A1	70405	4
SHEET 1 OF 1			

2015-80

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1		36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
2		84261-02	LEVER ASSEMBLY (RH/LH)
2		84261-01	HANDLE BAR ASSY

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ± 0.010 $\pm 1/2^\circ$
X.XX ± 0.03
X.X ± 0.1



AERO DESIGN LTD.

9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.488.8376 www.aerodesign.ca

**HELICOPTER CARGO BASKET
HANDLE BAR ASSEMBLY**

SCALE	SIZE	DWG. NO.	REV.
SCALE 1 : 1	A3	84261	2
SHEET 1 OF 1			

Work Order: 2015-85Date Opened: 08-Jul-15Material Tracking Sheet
Eurocopter AS350 / AS355
Medium Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		76410-01- <u>02</u>	Cargo Basket Assembly	(-01 RH, -02 LH)	<u>S/N 76402-34</u>
Step 1				<i>Lid Assembly</i>		
	. 1		69812-01	Basket Lid Assembly		<u>2015-36</u>
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	<u>15025</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		76427-01	Placard (right)	0.063 Sheet, 6061-T6 Aluminum	<u>N/A</u>
	. . 1		76427-02	Placard (left)	0.063 Sheet, 6061-T6 Aluminum	<u>11102</u>
	. . 4		CR3213-4-02	Cherry Rivet		<u>15014</u>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<u>14074</u>
	. . A/R		CR3213-4-02	Cherry Rivet		<u>15031</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		76411-01-XX	Basket Body Assembly		<u>2014-32</u>
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	<u>15006</u>
	. . 8		NAS1149F0663P	Washer		<u>14044</u>
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	72" <u>14091</u>	
	. 8		CR3523-5-02	Cherry Rivet	<u>15022</u>	
	. A/R		CR3213-5-02	Cherry Rivet	<u>15031</u>	
Step 4	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<u>2015-02</u>
	. . 4		AN3-11A	Bolt	} Previously Installed	<u>14048</u>
	. . 8		NAS1149F0363P	Washer		<u>14048</u>
	. . 4		MS21044N3	Nut		<u>15031</u>

Work Order: 2015-80Material Tracking Sheet
Eurocopter AS350 / AS355
Medium Basket Assembly

2 of 2

Date Opened: 08 JULY 2015

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		See attached sheet
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	13085
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	2013-33
	.. 2		AN3-12A	Bolt	13048 / 13084	
	.. 4		NAS1149F0363P	Washer	15014	
	.. 2		MS21044N3	Nut	13048 ne M072	
				Lid Brace Installation		
Step 5	. 1		36280-01	Brace Assembly		2015-63
	. 1		AN3-15A	Bolt	14084	
	. 1		AN3-17A	Bolt	14048	
	. 2		AN970-3	Washer	14084	
	. 3		NAS1149F0363P	Washer	15014	
	. 2		MS21044N3	Nut	14072	
Step 6				Inspection	None	



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: Tread Plate

Aircraft: All **Model:** N/A

Description: Lid Walkway Checker Plate

Supplier: Daigle Marine

Color: Aluminum

WO#: N/A

PO# 14074

2015-80 08-Jul-15

CARGO BASKET ASSEMBLY - COMMON

AS350 MED LH

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket

→ 76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

→ 70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2015-80

Date Open: 08 JULY 2015

JC.

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

JC.

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

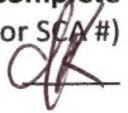
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

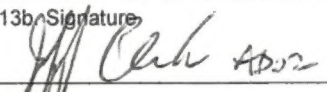
Complete
(initial or SCA #)



6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2015-80	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Med. Cargo Basket	76410-01-02	1	76402-34	New	
12. Remarks Left hand, Modified with walkway on lid and front end cutout IAW DCL704						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12.			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 22 June 2015		14d. Name		14e. Date (dd/mmm/yyyy)

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

153701724



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:	50	Alt:	
PN:	AN3-12A	Model:	All
Aircraft:	All		
Description:	Bolt		
Supplier:	Aviall		
Color:	N/A	PO#	Several
WO#:	N/A		